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United States
Department of
Agriculture

Food Safety
and Inspection
Service

Meat and Poultry
Inspection
Program

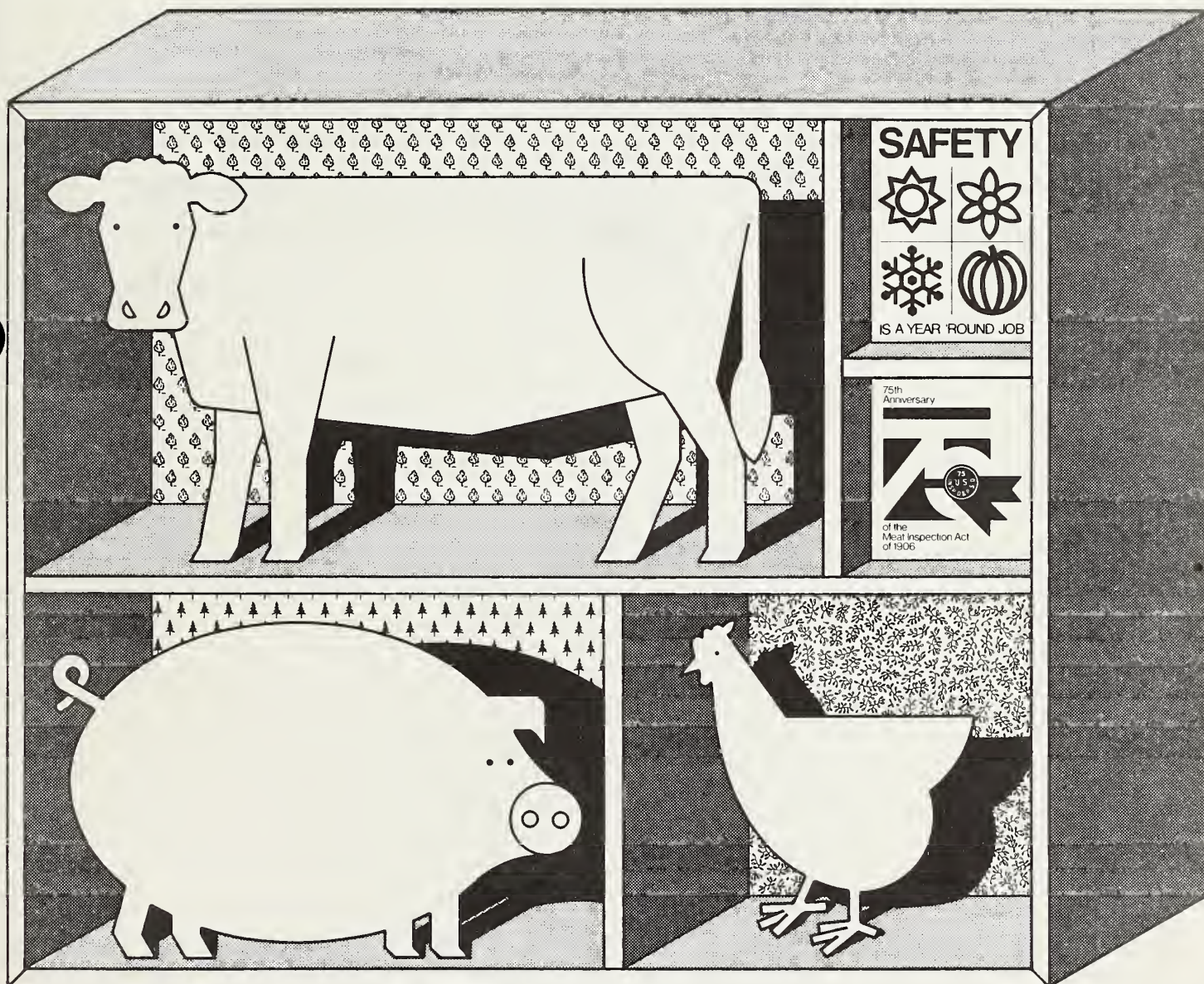
August 1982

Issuances of the Meat and Poultry Inspection Program

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82-8 Meat and Poultry Inspection
Manual

UNITED STATES DEPARTMENT OF AGRICULTURE
Food Safety and Inspection Service
Meat and Poultry Inspection
Washington, D.C. 20250

Meat and Poultry Inspection Manual

Date: August 1982

Change Number: 82-8

MAINTENANCE INSTRUCTIONS

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(d) Record

Each inspector shall have the "trim helper" record on MP Form 514 condemned carcasses in the appropriate blocks and all carcasses retained for veterinary examination under the word "retained" entered in the remarks space.

(1) Plant rejects. Unopened carcasses rejected by management before inspection shall be condemned and recorded on MP Form 514 under "other." The statement "Rejected by Plant Management" shall be entered under remarks. Plants desiring an official disposition of these carcasses must provide assistants for handling them and adequately lighted rack(s) in a place approved by the inspector in charge.

The inspector in charge or his designee will examine and dispose of such carcasses according to regulations. He will record condemned carcasses on an MP Form 514, maintained for this purpose only. Carcasses not condemned will be returned to the line by plant employees for evisceration and inspection.

Above operations will be conducted in an orderly and sanitary manner.

(2) Unlisted conditions. Carcasses condemned for unlisted abnormalities or diseases shall be recorded on MP Form 513, 514, and 514-1, under "remarks" or "other" with condemnation reason.

(e) Retained Product

When product is retained for further inspection, identity and wholesomeness should be preserved. Identity can be maintained by keeping product under Government lock or seal, and/or by using retained tags. Product wholesomeness can be maintained by preventing contamination, dehydration, and decomposition with plastic bags, slush ice, or other (refrigeration or freezing) means. If necessary, samples of retained product may be sent to the laboratory (see Part 23).

(f) Systemic Condition

When a systemic condition is evident, carcass and viscera must be condemned.

(g) Liver Condemnation

Livers with the following diseases or abnormalities must be condemned:

1. Fatty degeneration--characterized by well defined light spots. Livers with a uniform yellow color, due to excessive fat deposits (fatty infiltration), are considered wholesome. They are commonly found in fat birds, especially fowl, and occasionally fryers.

2. Extensive petechiae or hemorrhages. The typical "paint brush" appearance is considered insignificant.

3. Inflammation, abscess, necrosis.

4. Cirrhosis, tumor, cyst. Livers with one large cyst or several small cysts shall be condemned.

5. Discoloration--caused by gall bladder or bile duct disorders, post-mortem changes, etc.

6. Specific disease (entero-hepatitis).

7. Contamination--from intestinal contents or noxious materials.

(h) Kidney Condemnation

Kidneys shall be removed from carcasses showing:

1. Renal or splenic pathology.

2. Hepatic lesions causing liver condemnation.

3. Conditions requiring condemnations of all viscera.

4. Airsacculitis--when carcass or its posterior part is salvaged.

(i) Contamination

Carcass and/or part disposition shall be according to regulations (P-381.91). In lieu of condemnation, carcasses affected with certain contaminants such as feces or ingesta may be reprocessed and made acceptable by trimming.

(1) **Salvage operation.** Contaminated product may be salvaged, provided (1) adequate facilities and personnel are available, and (2) procedures, approved by area supervisor, are always done sanitarily.

(i) Facilities.

1. **Salvage station.** It should be in the eviscerating area and have adequate space for a sanitary and effective operation.

2. **Retain rack.** Each station shall have adequate retain racks in rows and high enough to prevent cross contamination of suspended carcasses.

3. **Trough or table.** A trough or table section with a steep, sloping top, drained into a gutter or other drainage facility, is necessary. A stainless steel grill for dropped hand tools is desirable over the table or trough.

4. **Singer.**

5. **Containers.** Vats, tanks, or other suitable containers for chilling product. Knife rack or stand.

6. **Spray nozzle** with proper fittings to clean carcasses.

7. **Gooseneck** or other acceptable facility for washing hands and tools.

8. A minimum of 50-foot candles of light.

* **(ii) Offline Salvaging Procedure**

1. After viscera removal, the trimmer may hang contaminated carcasses (by the neck) on designated area of retained rack.

2. Carcasses are then transferred from retain rack to salvage station, where they are suspended with anterior end up to prevent contamination during washing and trimming.

3. External carcass surfaces will be thoroughly washed before cutting.

4. Salvage must be done (a) by properly trimming contaminated tissues, (b) without cutting into the body cavity and opening cut edges.

5. Controls for salvage operations will be determined by the product handling capabilities at the salvage station and not at the individual inspection station. If retain racks are filled either at the inspection station or the salvage station, inspectors in charge should allow plants the option of disposing of contaminated birds, or adjusting the production rate. Birds disposed of by the plant should be recorded under "other" with a notation that the plant took the action. Inspectors in charge should not set an arbitrary limit on number of birds to be held at the inspection or salvage stations, but rather should be guided by good sanitary practices. Guidelines for judging efficiency of this operation could be significant loss of body temperature, drying of the skin surfaces and/or discoloration of carcasses.

6. Salvaged parts must be chilled immediately (with crushed ice in continuously drained containers).

(iii) Online Salvaging Procedure

Drumsticks which (a) have the end broken during the processing operation and have the bone protruding through the skin or (b) have tissue separated from the bone resulting in possible contamination (e.g., a short cut hock) may be trimmed on the line in a sanitary manner provided the trim cut is far enough down the drumstick to ensure that only wholesome tissue remains on the drumstick.

Short hocks in which tendons remain attached and simple fractures with no break in the skin do not require trimming.

(iv) Inspector's Responsibility

The inspector in charge must assure that all requirements are met and only wholesome product is saved for food purpose. A plant failing to comply with this section will discontinue salvage operations.

(2) **Overscald.** It should not be confused with hard scald. In overscald the skin slips from the meat, and the intestine may appear cooked.

Carcasses or parts partially cooked by singeing or other causes shall be condemned and recorded as overscald.

(j) Bruises; Tears

Trimming bruises, hemorrhages, or tears requires judgment based upon extent, nature, and practicability of trimming to meet ready-to-cook requirements. The following guides apply to ready-to-cook product only, and not to grading standards:

1. Entire carcass shall be condemned when a bruise or hemorrhage is associated with systemic disturbance.

2. When a condition is localized, the carcass may be passed for food after removal and condemnation of affected part(s).

3. Areas, showing blood clumps or clots in superficial tissues--between skin layers or superficial muscles (wing vein rupture), loose subcutaneous tissue, along blood vessels, etc.--may be slit and clots completely washed out before the part is passed for food. When blood clumps extend into muscles, affected part(s) shall be removed and condemned.

4. Areas with slight reddening shall be handled according to section 381.89 of the regulations.

(l) Breast blister. Although inflammatory tissue adheres tightly to keel bone, affected tissues must be removed.

Removal of breast blisters or other abnormalities before inspection is not permitted since it may affect carcass disposition.

Carcass chilling is not allowed before blister removal, except when carcasses are retained several hours for reinspection, or when blister-affected carcasses belong to lots of

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(l) Manteca, Manteca Pura

When "manteca" or "manteca pura" is used as a product name, the English designation "lard" or "rendered pork fat," as the case may be, must follow in close proximity.

(m) Shankless

When "shankless" is used in reference to a ham, it indicates the shank has been removed by a cut through the joint at a right angle to femur bone. The distal tip of the semitendinosus muscle may be severed above its tendinous attachment leaving an extension approximately 2 inches long. This extension is considered an integral part of the ham's body and is usually folded over the femur's end.

(n) Beefalo

The term "Beefalo" cannot substitute for "beef" in labeling. It can be featured as a further labeling term such as "beef from beefalo." Such usage will require that the establishment demonstrate an effective control system to the area supervisor to insure the term is used only with eligible products. The terms "calf" and "veal" apply to meat from young "beefalo" animals on the same basis as they are used with meat from other young bovines. See section 3.3.

(o) Ingredients

(1) Monosodium glutamate. When monosodium glutamate and hydrolyzed plant protein are used in product, they must be individually shown in the ingredient statement.

(2) Parsley, pistachio nuts, pickles. Although nearly every ingredient in a product contributes to its flavor, substances such as parsley, pistachio nuts, and pickles--not added to product solely for flavoring purpose--must be specifically named.

(3) Pimento, pimiento, red pepper.

Pimento or pimiento refers to the thick-walled, fleshy, conical-shaped sweet red pepper which may have a tough skin removable by a peeling process. The bell-shaped red pepper, from which the skin is usually not peeled, should not be designated "pimento" or "pimiento," but should be identified on labels as "red pepper." Most commercial pimento (or pimiento) and red pepper products are canned or frozen. They are produced and labeled to comply with Food and Drug Administration requirements.

(4) Smoked product. A product labeled "smoked" must be processed using smoke generated from hardwood, hardwood sawdust, corn cobs or from natural liquid smoke which has been transformed into a vapor (mist, fog, gas) by the application of direct heat or by mechanical means, e.g., atomization. *

(5) Smoke flavoring. If smoke flavoring or artificial smoke flavoring is added to product surface but not as an ingredient in the formula, product need not be labeled "smoke flavoring added" or "artificial smoke flavoring added." *

(6) Hickory smoke. If labeling of smoked product refers to "hickory smoke," plant shall provide the inspector with appropriate certification that such sawdust or wood used for smoking is 100 percent hickory. *

17.14 POULTRY**(a) Rock Cornish Game Hen; Cornish Game Hen**

The inspector must assure identity and true labeling by using adequate control from ante-mortem inspection through packaging.

(1) Age; slaughter. Ante-mortem inspector determines whether chickens

are only 5 to 6 weeks old, and assures they are slaughtered separately.

(2) Packaging, labeling.

(i) Separate. Carcasses, necks, and giblets shall be kept and packaged separately from like items of other broiler lots to prevent inclusion of oversized necks and giblets.

(ii) Net weight. Net weight of packaged product shall not exceed 2 pounds with or without neck and giblets. Stuffed product may weigh in excess of 2 pounds.

Do not use "rock cornish game hen" or "cornish game hen" on underweight frying chickens retained or removed from a straight run flock of commercial broilers.

(3) Supervision. To assure proper labeling, the inspector must closely supervise packaging and labeling operations.

(4) Labeling RTC product. Since the inspector has no knowledge upon which to make proper identification, ready-to-cook poultry must be labeled "rock cornish game hen" or "cornish game hen" before further processing, repacking, and relabeling.

(b) Cornish Roaster, Cornish Young Chicken

"Cornish" with other class names (cornish roaster, cornish young chicken, etc.) is applicable only when product is prepared from a purebred cornish chicken.

(c) Rock Cornish Roaster or Hen

"Rock cornish" with other class names (rock cornish roaster, rock cornish hen) is applicable only when product is a cross of rock and cornish breeds.

(d) Leghorn, Mediterranean Poultry

Leghorn or mediterranean breed type crosses shall not be labeled as "rock cornish game hen" or "cornish

game hen." White ear lobes would indicate that birds are leghorn or mediterranean.

(e) Capon

In a carcass, the presence of one complete testicle, or of partial testicles and minor secondary sex characteristics to the extent that half or more of a normal rooster comb and wattles are evident (bright red), disqualify the carcass from being labeled "capon." If the comb and wattles are white or nearly white, the carcass qualifies for labeling as "capon." When full secondary sex characteristics are evident, the label "capon" shall not be used (see 381.170). Occasionally a young bird with two complete testicles does not display secondary sex characteristics. This has been infrequent, but increases in frequency as the trend toward slaughtering younger birds continues. These birds qualify as roasters.

(f) Carcass

"Poultry" pertains to an entire carcass. Minor trimmings, including removal of breast blisters, minor skin abrasions, portion of wing at the humerus junction with radius and ulna, do not require special labeling -- "parts missing." This labeling is also not required on officially graded birds, if grade mark is on immediate container and product meets grade standards.

(g) Parts, Giblets

As defined in the regulations, "giblets" mean liver, heart, and gizzard. Section 381.170(b), states "giblets consist of approximately equal numbers of livers, hearts, and gizzards determined on a count basis."

(1) Hearts, gizzards. When a container bears a label "hearts and gizzards," it must contain approximately equal numbers of each. If the variance in equal count exceeds

10 percent of any item, the label shall read for example, "hearts and gizzards - mostly hearts," "hearts and livers - mostly livers," or "giblets - mostly gizzards."

(2) Division of giblets. A division of giblets, packed with individual bird carcasses, is permitted only to the extent that such carcasses may contain a liver, heart, and gizzard either whole or in part. In case of such division, the part shall not be less than one half the unit item heart, liver, or gizzard. Division of giblets is not permitted where shortage of giblets is the result of packing livers, gizzards, or hearts separately. Carcasses without giblets must be packed under labeling indicating "without giblets," or "parts missing."

(h) Parts Missing

"Parts missing" must appear as part of product name on all labels when product is packed without a significant part normally expected to be a part of entire carcass (drumstick, whole wing, whole leg, neck, major portion of breast, etc.).

(1) Without neck and/or giblets When product is packed without neck and/or giblets, labeling shall indicate either, "parts missing," "without necks," "without giblets" or "without neck and giblets," whichever is appropriate. The neck is not considered giblet; if missing, the label should state "neck missing," "without neck," "without giblets and neck," "parts missing," etc. Above terms must appear on the label directly below product name.

(2) Giblets parts missing. If a processor wishes to pack carcasses with heart and gizzard only, label should reflect this in product name with wording as "frying chicken" (parts of giblets missing, or with heart and gizzard) etc.

Insert label. Appropriate and applicable wording may be supplied on an insert-type label supplementing a previously approved label without such wording. The insert label may be used only when approved main label is a transparent bag or overwrap.

(3) Giblet, parts may be missing.

This term may be used on bulk-pack containers, but not on consumer-size packages.

(i) Fabricated Poultry

(1) Cuts. Unless product name is qualified to indicate deviation from a normal cut, all poultry parts must be cut according to the regulations (P-381.170). Where a cut is indicated in the regulations, the cut shall be made at that point through all tissues. In turkey breasts, neck skin from keel bone to whisker is allowed. Amounts over this must be stated on the label. In hen turkey breast, equivalent amounts of neck skin may be used.

(2) Breast cut. This cut includes white meat located on the outside of the clavicle, and attached to the breast meat. Product produced from more than one part and labeled as such shall contain natural proportions of named parts.

(3) Skin. Only sufficient skin to completely wrap product may be used. Skin overlapping is prohibited.

If skin in excess of this amount is used, product shall be labeled "skin added." An alternate method for boneless turkey thigh and breast roasts is to use not more than 15 percent skin. Test shall be done under inspector's supervision.

(j) Boneless Poultry

Deboned poultry product shall be labeled:

1. To show "kind" and "form," if not naturally deboned in large pieces (diced, chopped, finely chopped, emulsified, comminuted).

2. To show actual composition if other than natural proportions of skin and fat, as related to entire boneless carcass, are contained therein. Suitable labeling is provided by label reference to particular parts in products, i.e., comminuted, boneless chicken necks and backs, emulsified boneless chicken wings.

Alternatively, skin quantity can be indicated on the label, i.e., comminuted chicken meat with 40 percent skin (chicken necks have about 40 percent skin, chicken wings have about 35 percent skin).

3. Comminuted (kind) meat, if skin and fat are stripped from backs and necks before deboning.

4. If to be used in sausage "with kidneys and sex glands removed."

5. Cooked, if it is cooked.

(k) Canned Shredded Poultry

Shredded poultry must have shredded appearance. Mechanically deboned poultry product, produced by Bibum, Bee Hive, Paoli, and similar equipment, does not have a shredded appearance.

If product has skin in excess of natural proportions to a boneless whole bird, it must be so labeled. Most canned shredded poultry producers use cooked necks which are approximately 40 percent skin. Such product can be labeled as:

1. Shredded (kind) from necks,
2. Shredded (kind) meat with 40 percent skin, or
3. Shredded (kind) with 15 percent skin added.

(l) Poultry Treated with Additives

(l) Salt. Carcasses and parts treated with salt or other approved additive shall be labeled so that consumer is made aware that poultry has been so treated. Even though carcasses or parts may be institutionally packed, they shall be labeled to indicate additive used and its purpose.

(2) Caramel, turmeric spice. Caramel coloring and the spice "turmeric" may be included in formulas for poultry products, provided they are listed in the ingredients statement on the label for the product. U.S. certified colors and acceptable natural color dyes may be used if the wording "Color Added," "Artificially Colored," or similar wording appears as part of product name; such added color shall be declared in the ingredients statement by name identified as the coloring component.

(m) Smoked Product.

A product labeled "smoked" must be *
processed using smoke generated from *
hardwood, hardwood sawdust, corn cobs *
or from natural liquid smoke which has *
been transformed into a vapor (mist, *
fog, gas) by the application of direct *
heat or by mechanical means, e.g., *
atomization. *

* * *

PACKAGING MATERIAL

Subpart 17-D

(Regs: M-317, P-Subpart N,P,T)

Packaging materials include paper products (cartons, bags, band labels, wrappers, inserts, label stock, etc.); twine; plastics (films, bags, semi-rigid materials); glass and metal containers and closures (cans, jars, lids); aluminum foil; wood; etc.

17.16 ACCEPTANCE; RESPONSIBILITY

Generally, packages and packaging materials need not be sampled; however, if the inspector has reason to doubt their acceptability, he requires the plant or supplier to show a letter

of acceptance, and permits use of materials on the basis of such letter. If a material is changed and its acceptability is questionable, the inspector submits samples, with identifying marks, trade names or numbers, and other pertinent information, to

* FIAD at the address indicated below.

The inspector should be alert to the use and performance of all packages and packaging materials. Since certain materials may transfer color, odors, or disintegrate when used, final acceptance must be made by the inspector according to their performance under actual packaging conditions.

Plant management or supplier may obtain a letter of acceptance by submitting samples of the material

* with a statement of its chemical composition to FIAD at the following address:

* USDA, FSIS
* Food Ingredient Assessment Division
* Bldg. 306, BARC-East
* Beltsville, MD 20705

* * *

17.17 STOCKINET

Properly labeled or marked product may be covered with loosely woven stockinet, provided the marks are plainly visible through the covering.

17.18 TALC; STARCH; ALUMINUM FOIL

A small quantity of food grade talc or starch dusted on plastic films to prevent sticking is considered harmless.

Lead-free aluminum foil and its products are not toxic. However, products with considerable quantities of salt or acidic ingredients, such as tomatoes, vinegar, barbecue sauce, etc., may corrode the aluminum packaging material and cause package failure and product contamination. To prevent corrosion, such material should be coated with an approved resinous or polymeric substance and should withstand temperatures up to 450° F. (see section 17.16).

MEAT AND POULTRY INSPECTION REGULATIONS

MAINTENANCE INSTRUCTIONS

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Establishment Numbers: August 6, 1982
Mechanically Separated (Species): July 29, 1982
Cooked Beef, Roast Beef, and Cooked
 Corned Beef: July 23, 1982

(§ 317.2(c) continued)

(3) The name and place of business of the manufacturer, packer, or distributor for whom the product is prepared, as prescribed in paragraph (g) of this section;

(4) An accurate statement of the net quantity of contents, as prescribed in paragraph (h) of this section;

(5) An official inspection legend and, except as otherwise provided in paragraph (i) of this section, the number of the official establishment, in the form required by Part 312 of this subchapter;

(6) Any other information required by the regulations in this part or Part 319 of this subchapter.

(d) The principal display panel shall be the part of a label that is most likely to be displayed, presented, shown, or examined under customary conditions of display for sale. Where packages bear alternate principal display panels, information required to be placed on the principal display panel shall be duplicated on each principal display panel. The principal display panel shall be large enough to accommodate all the mandatory label information required to be placed thereon by this part and Part 319 of this subchapter with clarity and conspicuousness and without obscuring of such information by designs or vignettes or crowding. In determining the area of the principal display panel, exclude tops, bottoms, flanges at tops and bottoms of cans, and shoulders and necks of bottles or jars. The principal display panel shall be:

(1) In the case of a rectangular package, one entire side, the area of which is at least the product of the height times the width of that side.

(2) In the case of a cylindrical or nearly cylindrical container:

(i) An area that is 40 percent of the product of the height of the container times the circumference of the container, or (ii) a panel, the width of which is one-third of the circumference and the height of which is as high as the container: Provided, however, That if there is immediately to the right or left of such principal display panel, a panel which has a width not greater than 20 percent of the circumference and a height as high as the container, and which is reserved for information prescribed in subparagraphs (c)(2), (3) and (5), such panel shall be known as the "20 percent panel" and such information may be shown on that panel in lieu of showing it on the principal display panel. *

(3) In the case of a container of any other shape, 40 percent of the total surface of the container.

(e) Any descriptive designation used as a product name for a product which has no common or usual name shall clearly and completely identify the product. Product which has been prepared by salting, smoking, drying, cooking, chopping, or otherwise shall be so described on the label unless the name of the product implies, or the manner of packaging shows that the product was subjected to such preparation. The unqualified terms "meat," "meat byproduct," "meat food product," and terms common to the meat industry but not common to consumers such as "picnic," "butt," "cala," "square," "loaf," "spread," "delight," "roll," "plate," "luncheon," and "daisy" shall not be used as names of a product unless accompanied with terms descriptive of the product or with a list of ingredients, as deemed necessary in any specific case by the Administrator in order to assure that the label will not be false or misleading.

(§ 317.2 continued)

(f) (1) The list of ingredients shall show the common or usual names of the ingredients arranged in the descending order of predominance, except as otherwise provided in this paragraph.

(i) The term "flavorings" may be used to designate natural spices, essential oils, oleoresins and other natural spice extractives, and the term "spices" may be used to designate natural spices, without naming each.

(ii) The term "corn syrup" may be used to designate either corn syrup or corn syrup solids.

(iii) The term "animal and vegetable fats" or "vegetable and animal fats" may be used to designate the ingredients of mixtures of such edible fats in product designated "compound" or "shortening." "Animal fats" as used herein means fat derived from inspected and passed cattle, sheep, swine, or goats.

(iv) When a product is coated with pork fat, gelatin, or other approved substance and a specific declaration of such coating appears contiguous to the name of the product, the ingredient statement need not make reference to the ingredients of such coating.

(v) When two meat ingredients comprise at least 70 percent of the meat and meat byproduct ingredients of a formula and when neither of the two meat ingredients is less than 30 percent by weight of the total meat and meat byproducts used, such meat ingredients may be interchanged in the formula without a change being made in the ingredients statement on labeling materials: Provided, That the word "and" in lieu of a comma shall be shown between the declaration of such meat ingredients in the statement of ingredients.

(2) On containers of frozen dinners, entrees, pizzas, and similar consumer packaged products in cartons the ingredient statement may be placed on the front riser panel: Provided, That the words "see ingredients" followed immediately by an arrow is placed on the principal display panel immediately above the location of such statement without intervening print or designs.

(3) The ingredient statement may be placed on the 20 percent panel adjacent to the principal display panel and reserved for required information, in the case of a cylindrical or nearly cylindrical container.

(g) (1) The name or trade name of the person that prepared the product may appear as the name of the manufacturer or packer without qualification on the label. Otherwise the name of the distributor of the product shall be shown with a phrase such as "Prepared for * * *." The place of business of the manufacturer, packer, or distributor shall be shown on the label by city, State, and postal ZIP code when such business is listed in a telephone or city directory, and if not listed in such directory, they the place of business shall be shown by street address, city, State, and postal ZIP code.

(2) The name and place of business of the manufacturer, packer, or distributor may be shown:

(i) On the principal display panel or

(ii) On the 20 percent panel and adjacent to the principal display panel and reserved for required information, in the case of a cylindrical or nearly cylindrical container, or

(iii) On the front riser panel of frozen food cartons.

(§ 317.2(h) continued)

(10) Labels for containers which bear any representation as to the number of servings contained therein shall bear, contiguous to such representation, and in the same size type as is used for such representation, a statement of the net quantity of each such serving.

(11) As used in this section a "random weight package" is one which is one of a lot, shipment, or delivery of packages of the same product with varying weights and with no fixed weight pattern.

(12) On a multiunit retail package, a statement of the net quantity of contents shall appear on the outside of the package and shall include the number of individual units, the quantity of each individual unit, and, in parentheses, the total net quantity of contents of the multiunit package in terms of avoirdupois or fluid ounces, except that such declaration of total quantity need not be followed by an additional parenthetical declaration in terms of the largest whole units and subdivisions thereof, as required by subparagraph (5) of this paragraph. For the purposes of this section, "multiunit retail package" means a package containing two or more individually packaged units of the identical commodity and in the same quantity, with the individual packages intended to be sold as part of the multiunit retail package but capable of being individually sold in full compliance with all requirements of the regulations in this part. Open multiunit retail packages that do not obscure the number of units and the labeling thereon are not subject to this paragraph if the labeling of each individual unit complies with the requirements of subparagraphs (2), (3), (6), and (8) of this paragraph.

(13) Shingle packed sliced bacon cartons containing product weighing other than 8 ounces, 1 pound, or 2 pounds shall have the statement of the net quantity of contents shown with the same prominence as the most conspicuous feature on the label and printed in a color of ink contrasting sharply with the background and such containers of sliced bacon that are rectangular are exempt from the requirements of subparagraphs (3) and (5) of this paragraph regarding the placement of the statement of the net quantity of contents within the bottom 30 percent of the principal display panel and that the statement be expressed both in ounces and in pounds.

(i) The official establishment number of the official establishment in which the product was processed under inspection shall be placed as follows:

(1) Within the official inspection legend in the form required by Part 312 of this subchapter; or

(2) Outside the official inspection legend elsewhere on the exterior of the container or its labeling, e.g., the lid of a can, if shown in a prominent and legible manner in a size sufficient to insure easy visibility and recognition and accompanied by the prefix "EST"; or

(3) Off the exterior of the container, e.g., on a metal clip used to close casings or bags, or on the back of a paper label of a canned product, or on other packaging or labeling material in the container e.g., on aluminum pans and trays placed within containers, when a statement of its location is printed contiguous to the official inspection legend, such as "EST. No. on Metal Clip" or "Est. No. on Pan", if shown in a prominent and legible manner in a size sufficient to insure easy visibility and recognition; or

(4) On an insert label placed under a transparent covering if clearly visible and legible and accompanied by the prefix "EST".

(j) Labels of any product within any of the following paragraphs shall show the information required by such paragraph for such product:

(1) A label for product which is an imitation of another food shall bear the word "imitation" immediately preceding the name of the food imitated and in the same size and style of lettering as in that name and immediately thereafter the word "ingredients:" and the names of the ingredients arranged in the order of their predominance.

(2) If a product purports to be or is represented for any special dietary use by man, its label shall bear a statement concerning its vitamin, mineral, and other dietary properties upon which the claim for such use is based in whole or in part and shall be in conformity with regulations (21 CFR Part 125) established pursuant to sections 403 and 701 of the Federal Food, Drug, and Cosmetic Act (21 U.S.C. 343, 371).

(3) When an approved artificial smoke flavoring or an approved smoke flavoring is added as an ingredient in the formula of a meat food product, as

(§ 317.2(j)(3) continued)

permitted in Part 318 of this subchapter, there shall appear on the label, in prominent letters and contiguous to the name of the product, a statement such as "Artificial Smoke Flavoring Added" or "Smoke Flavoring Added," as may be applicable, and the ingredient statement shall identify any artificial smoke flavoring or smoke flavoring so added as an ingredient in the formula of the meat food product.

(4) When any other artificial flavoring is permitted under Part 318 of this subchapter to be added to a product, the ingredient statement shall identify it as "Artificial Flavoring."

(5) When artificial coloring is added to edible fats as permitted under Part 318 of this subchapter such substance shall be declared on the label in a prominent manner and contiguous to the name of the product by the words "Artificially colored" or "Artificial coloring added" or "With added artificial coloring." When natural coloring such as annatto is added to edible fats as permitted under Part 318 of this subchapter, such substance shall be declared on the label in the same manner by a phrase such as "Colored with annatto."

(6) When product is placed in a casing to which artificial coloring is applied as permitted under Part 318 of this subchapter, there shall appear on the label, in a prominent manner and contiguous to the name of the product, the words, "Artificially colored."

(7) If a casing is removed from product at an official establishment and there is evidence of artificial coloring on the surface of the product, there shall appear on the label, in a prominent manner and contiguous to the name of product, the words "Artificially colored."

(8) When a casing is colored prior to its use as a covering for product and the color is not transferred to the product enclosed in the casing, no reference to color need appear on the label but no such casing may be used if it is misleading or deceptive with respect to color, quality, or kind of product, or otherwise.

(9) Product which bears or contains any other artificial coloring, as permitted under Part 318 of this subchapter, shall bear a label stating that fact on the immediate container or if there is none, on the product.

(10) When an antioxidant is added to product as permitted under Part 318 of this subchapter, there shall appear on the label in prominent letters and contiguous to the name of the product, a statement identifying the officially approved specific antioxidant by its common name or abbreviation thereof and the purpose for which it is added, such as, "BHA, BHT, and Propyl gallate added to help protect flavor."

(11) Containers of meat packed in borax or other preservative for export to a foreign country which permits the use of such preservative shall, at the time of packing, be marked "for export," followed on the next line by the words "packed in preservative," or such equivalent statement as may be approved for this purpose by the Administrator and directly beneath this there shall appear the word "establishment" or abbreviation thereof, followed by the number of the establishment at which the product is packed. The complete statement shall be applied in a conspicuous location and in letters not less than 1 inch in height.

(12) Containers of other product packed in, bearing, or containing any chemical preservative shall bear a label stating that fact.

(§ 317.2(j) continued)

(13)(i) On the label of any "Mechanically Separated (Species)" described in § 319.5(a) of this subchapter, the name of such product shall be followed immediately by the phrase "for processing" unless such product has a protein content of not less than 14 percent and a fat content of not more than 30 percent.

(ii) When any "Mechanically Separated (Species)" described in § 319.5 of this subchapter is used as an ingredient in the preparation of a meat food product and such "Mechanically Separated (Species)" contributes 20 mg or more of calcium to a serving of such meat food product, the label of such meat food product shall state the calcium content of such meat food product, determined and expressed as the percentage of the U.S. Recommended Daily Allowance (U.S. RDA) in a serving in accordance with 21 CFR 101.9(b)(1), (c)(7)(i) and (iv), and (e), as part of any nutrition information included on such label, or if such meat food product does not bear nutrition labeling information, as part of a prominent statement in immediate conjunction with the list of ingredients, as follows: "A _____ serving contains ___% of the U.S. RDA of calcium", with the blanks to be filled in, respectively, with the quantity of such product that constitutes a serving and the amount of calcium provided by such serving: **Provided**, That, calcium content need not be stated where (a) the percent of the U.S. RDA of calcium to be declared would not differ from the percent of the U.S. RDA that would be declared if the meat food product contained only hand deboned ingredients or (b) the calcium content of a serving of the meat food product would be 20 percent of the U.S. RDA or more if the meat food product contained only hand deboned ingredients.

(k) Packaged products which require special handling to maintain their wholesome condition shall have prominently displayed on the principal display panel of the label the statement: "Keep Refrigerated," "Keep Frozen," "Perishable Keep Under Refrigeration," or such similar statement as the Administrator may approve in specific cases. Products that are distributed frozen during distribution and thawed prior to or during display for sale at retail shall bear the statement on the shipping container: "Keep Frozen." The consumer-size containers for such products shall bear the statement "Previously Handled Frozen for Your Protection, Refreeze or Keep Refrigerated." For all perishable canned products the statement shall be shown in upper case letters one-fourth inch in height for containers having a net weight of 3 pounds or less, and for containers having a net weight over 3 pounds, the statement shall be in upper case letters at least one-half inch in height.

§ 317.3 Approval of abbreviations of marks of inspection; preparation of marking devices bearing inspection legend without advance approval prohibited; exception.

(a) The Administrator may approve and authorize the use of abbreviations of marks of inspection under the regulations in this subchapter. Such abbreviations shall have the same force and effect as the respective marks for which they are authorized abbreviations.

(b) Except for the purpose of submitting a sample or samples of the same to the Administrator for approval, no person shall procure, make, or prepare, or cause to be procured, made, or prepared, labels, brands, or other marking devices bearing the inspection legend or any abbreviations, copy or

(§ 318.14(b) continued)

one-half of 1 percent available chlorine (5,000 parts per million or other equivalent disinfectant approved by the Administrator¹ shall be applied to the surface of the rooms and equipment and rinsed with potable water before use.

(c) Hermetically sealed containers of product which have been contaminated by polluted water shall be examined promptly by the official establishment under supervision of an inspector and rehandled as follows:

(1) Separate and condemn all product in damaged or extensively rusted containers.

(2) Remove paper labels and wash the remaining containers in warm soapy water, using a brush where necessary to remove rust or other foreign material. Disinfect these containers by either of the following methods:

(i) Immerse in a solution of sodium hypochlorite containing not less than 100 parts per million of available chlorine or other equivalent disinfectant approved by the Administrator,¹ rinse in potable water, and dry thoroughly; or

(ii) Immerse in 212° F. water, bring temperature of the water back to 212° F. and maintain the temperature at 212° F. for 5 minutes, then remove containers from water and cool them to 95° F. and dry thoroughly.

(3) After handling as described in subparagraph (2) of this paragraph, the containers may be relacquered, if necessary, and then relabeled with approved labels applicable to the product therein.

(4) The identity of the canned product shall be maintained throughout all stages of the rehandling operations to insure correct labeling of the containers.

§ 318.15 Tagging chemicals, preservatives, cereals, spices, etc., "U.S. retained."

When any chemical, preservative, cereal, spice, or other substance is intended for use in an official establishment, it shall be examined by a Program employee and if found to be unfit or otherwise unacceptable for the use intended, or if final decision regarding acceptance is deferred pending laboratory or other examination, the employee shall attach a "U.S. retained" tag to the substance or container thereof. The substance so tagged shall be kept separate from other substances as the circuit supervisor may require and shall not be used until the tag is removed, and such removal shall be made only by a Program employee after a finding that the substance can be accepted, or, in the case of an unacceptable substance, when it is removed from the establishment.

§ 318.16 Pesticide chemicals and other residues in products.

(a) Nonmeat ingredients. Residues of pesticide chemicals, food additives and color additives or other substances in or on ingredients (other than meat, meat byproducts, and meat food products) used in the formulation of products shall not exceed the levels permitted under the Federal Food, Drug, and

¹ A list of approved disinfectants is available upon request to Scientific Services, Meat and Poultry Inspection Program, Food Safety and

* Inspection Service, U.S. Department of Agriculture, Washington, D.C. 20250. *

(§ 318.16(a) continued)

Cosmetic Act, and such nonmeat ingredients must otherwise be in compliance with the requirements under that Act.

(b) Products, and meat, meat byproduct, or other meat food product ingredients. Products, and products used as ingredients of products, shall not bear or contain any pesticide chemical, food additives, or color additive residue in excess of the level permitted under the Federal Food, Drug, and Cosmetic Act and the regulations in this subchapter, or any other substance that is prohibited by such regulations or that otherwise makes the products adulterated.

(c) Standards and procedures. Instructions specifying the standards and procedures for determining when ingredients of finished products are in compliance with this section shall be issued to the inspectors by the Administrator. Copies of such instructions will be made available to interested persons upon request made to the Administrator.

§ 318.17 Requirements for the production of cooked beef, roast beef, and cooked corned beef.

(a) Cooked beef, roast beef, and cooked corned beef shall be prepared by one of the time and temperature combinations described in the following table, provided that the procedure produces and maintains the minimum temperature required in all parts of each roast for at least the stated period:

TABLE FOR TIME/TEMPERATURE COMBINATION
FOR COOKED BEEF, ROAST
BEEF, AND COOKED CORNED BEEF

Minimum internal temperature		Minimum processing time
°F	°C	in minutes after minimum temperature is reached
130	54.4	121
131	55.0	97
132	55.6	77
133	56.1	62
134	56.7	47
135	57.2	37
136	57.8	32
137	58.4	24
138	58.9	19
139	59.5	15
140	60.0	12
141	60.6	10
142	61.1	8
143	61.7	6
144	62.2	5
145	62.8	Instantly

(§ 318.17 continued)

* (b) Cooked beef or cooked corned beef shall be moist cooked. It shall
* be either (1) placed in a sealed, moisture impermeable bag, from which the
* excess air has been removed, and cooked in a water bath or oven, or
* (2) completely immersed, unbagged, in water throughout the entire cooking
* process.

* (c) Roast beef shall be cooked either (1) by heating roasts of
* 10 pounds or more in netting or on racks using dry heat in an oven
* maintained at 250°F (121°C) or higher throughout the process; or (2) by
* heating roasts of any size in an oven maintained at any temperature that
* will satisfy the internal temperature and time requirements of paragraph (a)
* if the relative humidity of the oven is maintained above 90 percent for at
* least 25 percent of the total cooking time, but in no case for less than
* 1 hour. This relative humidity may be achieved by use of steam injection or
* by sealed ovens capable of producing and maintaining the required 90 percent
* relative humidity.

* (d)(1) Except as provided in paragraph (d)(2), establishments producing
* cooked beef, roast beef, and cooked corned beef shall have sufficient
* monitoring equipment, including recording devices, to assure that the time
* (within 1 minute), temperature (within 1°F) and relative humidity (within
* 5 percent) limits required by these processes are being met. Data from the
* recording devices shall be made available to a program employee upon
* request.

* (2) In lieu of recording devices, establishments may propose in the
* written procedures prescribed in paragraph (f) of this section, an
* alternative means of providing inspection personnel with evidence that
* finished product has been prepared in compliance with the humidity
* requirements of paragraph (c) of this section, and the 145°F temperature
* requirement of paragraph (a) of this section.

* (e) Each package of finished product shall be plainly and permanently
* marked on the immediate container with the date of production either in code
* or with the calendar date.

* (f) In order to assure that cooked beef, roast beef, and cooked corned
* beef are handled, processed, and stored under sanitary conditions, the
* establishment shall submit a set of written procedures through the inspector
* in charge for approval by the Regional Director. The written procedures
* shall contain the following information:

* (1) The temperature to which frozen product is thawed and the time
* required.

* (2) The lot identification procedure for lots of product during
* processing.

* (3) The processing and storage time and temperature combinations which
* the establishment intends to use.

* (4) The time, if any, the establishment intends to wait after cooking
* and before cooling.

* (5) If a code is used on the immediate container of the finished
* product, its meaning shall also be included.

* (6) Any other critical control points in the procedures which could
* affect the safety of the product.

* (7) In lieu of recording devices, the alternate means permitted by
* § 318.17(d)(2) of providing evidence to inspection personnel that the
* finished product will be prepared in compliance with temperature or humidity
* requirements.

(g) The establishment shall maintain records and reports which document the time, temperature, and humidity at which any cooked beef, roast beef, or cooked corned beef is prepared at the establishment. Such records shall be kept by the establishment for 6 months or for such further period as the Administrator may require for purposes of any investigation or litigation under the Act, by written notice to the person required to keep such records. Such records shall be made available to a program employee upon request.

(h) The handling, processing, and storing of cooked beef, roast beef, and cooked corned beef before, during, and after cooking shall be controlled by the establishment as follows:

(1) The establishment shall notify the inspector in charge which processing procedure will be used on each lot, including time and temperature.

(2) In order to assure uniform heat penetration and consequent adequate cooking of each piece of beef, individual pieces of raw product in any one lot shall not vary in weight by more than 2 pounds nor in thickness by more than 2 inches at the thickest part. Alternate methods of assuring uniform heat penetration may be submitted in writing for approval to Processed Products Inspection Division, Meat and Poultry Inspection Technical Services, Food Safety and Inspection Service, U.S. Department of Agriculture, Washington, DC 20250.

(3) A water-based solution that is used for injecting or immersing the meat shall be refrigerated to 50°F or lower from the time it contacts the meat, and shall be filtered each time it is recirculated or reused.

(4) A nonmeat ingredient, including the water-based solution in (h)(3) above, which has contacted meat shall be discarded at the end of that day's production.

(5) Product prepared for cooking shall be entered into the cooking cycle or be chilled to an internal temperature of 40°F or lower within 2 hours of the completion of precooking preparation.

(6) The time and temperature requirements shall be met before any product in the lot is removed from the cooking units. Unless otherwise specified in the written procedures approved in accordance with paragraph (f) of this section, the heat source shall not be shut off until these requirements are met.

(7) Other than incidental contact caused by water currents during immersion cooking or cooling, product shall be placed so that it does not touch or overlap other product.

(8) Temperature sensing devices shall be so placed that they monitor product and, when oven temperature is required by paragraph (c) of this section, oven temperature in the coldest part of the cooking unit.

(9) If a humidity sensing device is required in an oven, it shall be placed so that it measures humidity in either the oven chamber or at the exit vent.

(10) Chilling shall begin within 90 minutes after the cooking cycle is completed, and the product shall be chilled to an internal temperature of 40°F or lower within 7½ hours after the cooking cycle is completed, unless an alternate chilling procedure is used. Alternate chilling procedures shall first be approved by the Processed Products Inspection Division, Meat and Poultry Inspection Technical Services, Food Safety and Inspection Service, U.S. Department of Agriculture, Washington, DC 20250.

(§ 318.17(g) continued)

- * Request for approval of alternate chilling procedures shall be submitted in
* writing and shall provide complete details and supporting data. *
- * (11) Any establishment that has experienced a cooking process deviation
* during preparation of product may either reprocess the product completely,
* continue the heating to 145°F or contact the Regional Director for a review
* of the process schedule for adequacy and, if needed, for a cooking schedule
* to finish this one batch of product. *
- * (12) An establishment that has experienced a cooling deviation after
* the product has been cooked shall contact the Processed Products Inspection
* Division to determine the disposition of that retained product. *
- * (i) Cooked beef, roast beef, and cooked corned beef shall be so
* handled as to assure that the product is not recontaminated by direct or
* indirect contact with raw product. To prevent direct contamination of the
* cooked product, establishments shall (1) physically separate areas where raw
* product is handled from areas where exposed cooked product is handled, using
* a solid impervious floor to ceiling wall; or (2) handle raw and exposed
* cooked product at different times, with a cleaning of the entire area after
* the raw material handling is completed and prior to the handling of cooked
* product in that area; or (3) submit a written procedure for approval to the
* Processed Products Inspection Division, detailing the steps to be taken
* which would avoid recontamination of cooked product by raw product during
* processing. *
- * (j) To prevent indirect contamination of cooked product, (1) any work
* surface, machine, or tool which contacts raw product shall be thoroughly
* cleaned and sanitized with a solution germicidally equivalent to 50 ppm
* chlorine before it contacts cooked product; (2) employees shall wash their
* hands and sanitize them with a solution germicidally equivalent to 50 ppm
* chlorine whenever they enter the heat processed product area or before
* preparing to handle cooked product, and as frequently as necessary during
* operations to avoid product contamination; and (3) outer garments, including
* aprons, smocks, and gloves shall be especially identified as restricted for
* use on cooked product only, changed at least daily, and hung in a designated
* location when the employee leaves the area. *
- * (k) Cooked product shall not be stored in the same room as raw product
* unless it is first packaged in a sealed, water-tight container. *

§ 318.18 Handling of certain material for mechanical processing.

- * Material to be processed into "Mechanically Separated (Species)" shall be so
* processed within 1 hour from the time it is cut or separated from carcasses
* or parts of carcasses, except that such product may be held for no more than
* 72 hours at 40° F. (4° C.) or less, or held indefinitely at 0° F. (-18° C.)
* or less. "Mechanically Separated (Species)" shall directly after being
* processed, be used as an ingredient in a meat food product except that it may
* be held prior to such use for no more than 72 hours at 40° F. (4° C.) or less
* or indefinitely at 0° F. (-18° C.) or less. *

PART 319-DEFINITIONS AND STANDARDS OF IDENTITY OR COMPOSITION

AUTHORITY: The provisions of this Part 319 issued under sec. 21, Federal Meat Inspection Act, as amended by the Wholesome Meat Act (21 U.S.C. Supp., sec. 601 **et seq.**), and Public Law 91-342; Talmadge-Aiken Act of Sept. 28, 1962 (7 U.S.C. 450); Act of July 24, 1919 (7 U.S.C 394); subsection 21(b), Federal Water Pollution Control Act, as amended by Public Law 91-224 and by other laws.

Subpart A-General

§ 319.1 Labeling and preparation of standardized products.

Labels for products for which standards of identity or composition are prescribed in this part shall show the appropriate product name, an ingredient statement, and other label information in accordance with the special provisions, if any, in this part, and otherwise in accordance with the general labeling provisions in Part 317 of this subchapter, and such products shall be prepared in accordance with the special provisions, if any, in this part and otherwise in accordance with the general provisions in this subchapter. Any product for which there is a common or usual name must consist of ingredients and be prepared by the use of procedures common or usual to such products insofar as specific ingredients or procedures are not prescribed or prohibited by the provisions of this subchapter.

§ 319.2 Products and nitrates and nitrites.

Any product, such as frankfurters and corned beef, for which there is a standard in this Part and to which nitrate or nitrite is permitted or required to be added, may be prepared without nitrate or nitrite and labeled with such standard name when immediately preceded with the term "Uncured" in the same size and style of lettering as the rest of such standard name: Provided, That the product is found by the Administrator to be similar in size, flavor, consistency, and general appearance to such product as commonly prepared with nitrate and nitrite: And provided further, That labeling for such product complies with the provisions of § 317.17(c) of this subchapter.

§§ 319.3-319.4 [Reserved]

* § 319.5 Mechanically Separated (Species).

* (a) Mechanically Separated (Species) is any finely comminuted product
* resulting from the mechanical separation and removal of most of the bone
* from attached skeletal muscle of livestock carcasses and parts of carcasses
* and meeting the other provisions of this paragraph. Examples of such
* product are "Mechanically Separated Beef", "Mechanically Separated Veal",
* "Mechanically Separated Pork", and "Mechanically Separated Lamb". At least
* 98 percent of the bone particles present in such product shall have a
* maximum size no greater than 0.5 millimeter in their greatest dimension and
* there shall be no bone particles larger than 0.85 millimeter in their
* greatest dimension. The product resulting from the separating process shall
* not have a calcium content exceeding 0.75 percent, as a measure of a bone
* solids content of not more than 3 percent, and shall have a minimum PER of
* 2.5 (except as modified in paragraph (e)(1) of this section). Such product
* also shall have a protein content of not less than 14 percent and a fat
* content of not more than 30 percent, or it shall be deemed to be product for
* processing. Such product failing to meet the bone particle size, calcium,
* or PER requirements of this paragraph shall only be used in producing animal
* fats. Where such product meets the bone particle size, calcium, and PER
* requirements of this paragraph, it may also be used in the formulation of
* meat food products in accordance with § 319.6.

* (b)-(d) [Reserved]

(e)(1) An essential amino acid content of at least 33 percent of the total amino acids present in "Mechanically Separated (Species)" shall be accepted as evidence of compliance with the protein quality requirement set forth in paragraph (a) of this section. For purposes of this paragraph, essential amino acid content includes isoleucine, leucine, lysine, methionine, phenylalanine, threonine, and valine content, and the total amino acids present include isoleucine, leucine, lysine, methionine, phenylalanine, threonine, valine, tyrosine, arginine, histidine, alanine, aspartic acid, glutamic acid, glycine, proline, serine, and hydroxyproline content.

(2) A prerequisite for label approval for products consisting of or containing "Mechanically Separated (Species)" is that such "Mechanically Separated (Species)" shall have been produced by an establishment under an approved plant quality control system. The Administrator shall receive, evaluate, and approve requests for plant quality control in accordance with § 318.4(d)(1) and (2) and (e) of this subchapter. Such a plant quality control system shall provide the controls and information necessary to assure that the product will meet the requirements described in § 319.5(a) and to enable establishment personnel and program employees to monitor the system for effectiveness. The system shall include a written description of the methods used by the establishment to maintain uniformity of the raw ingredients used in manufacturing product, to control the handling and processing of the raw ingredients and the finished product, and shall contain provisions for chemical analyses of the product and other procedures to determine and assure compliance with standards for the product. For purposes of this paragraph, a lot shall consist of the "Mechanically Separated (Species)" designated as such by the operator of the establishment or his or her agent from the product produced from a single species of livestock in no more than one continuous shift of up to 12 hours. All units of any lot must be available for inspection by program employees. Analysis of a sample of at least 1 pound from each lot to verify contents of fat, protein, and calcium in "Mechanically Separated (Species)" shall be performed by the operator of the establishment or his or her agent to assure that finished product will meet the requirements in § 319.5(a), except that such analyses with respect to fat, protein, and calcium content shall be required to be performed with respect to only one randomly selected lot of every five lots if the preceding ten analyses and all such analyses performed by the Department during the preceding ten analyses period establish compliance with the requirements of § 319.5(a), and that no analyses with respect to fat or protein content shall be required where the finished product is represented as product for processing. An analysis of a sample of at least 1 pound to verify essential amino acid content and/or protein efficiency ratio in "Mechanically Separated (Species)" shall be performed by the operator of the establishment or his or her agent at the rate of at least one per month during production to assure that finished product will meet the requirements of § 319.5(a), except that such analyses with respect to essential amino acid content and/or protein efficiency ratio shall be required to be performed only once every 6 months if the preceding

(§ 319.5(e)(2) continued)

three analyses and all such analyses performed by the Department during the preceding three analyses period establish compliance with the requirements of § 319.5(a). Finished product samples shall be analyzed in accordance with "Official Methods of Analysis of the Association of Official Analytical Chemists" (AOAC), 13th ed., 1980, sections 24.005 (page 376), 24.006-24.008 (page 376), 24.027 (page 379), and 43.212-43.216 (page 774-75) and the "2nd Supplement to the 13th Edition" (J.AOAC, Vol. 64, No. 2, 1981), section 24.B01-24.B03 (pages 509-10), which are incorporated by reference, or if no AOAC method is available, in accordance with the "Chemistry Laboratory Guidebook," U.S. Department of Agriculture, Washington, D.C., sections 6.009-6.009F (pages 6-31 through 6-34) and 6.010-6.010D (pages 6-35 through 6-41). Alternative methods of analysis may be submitted to the Administrator to determine their acceptability based upon their accuracy, repeatability, reproducibility, and lowest level of reliable measurement, as demonstrated by at least 3 laboratories. (Copies of the AOAC methods may be obtained from: AOAC, 1111 N. 19th Street, Arlington, VA 22209. Copies of the Chemistry Laboratory Guidebook may be obtained from: Superintendent of Documents, Government Printing Office, Washington, DC 20402. This incorporation by reference was approved by the Director of the Federal Register on December 30, 1981 and March 15, 1982. These materials are incorporated as they exist on the date of the approval. A notice of any change in the sections of the AOAC methods or the Chemistry Laboratory Guidebook cited herein will be published in the Federal Register.) The plant quality control system shall be subject to periodic review, and the approval of such system may be terminated in accordance with § 318.4(g)(2) of this subchapter.

§ 319.6 Limitations with respect to use of Mechanically Separated (Species).

(a) Meat food products required to be prepared from one species shall not contain Mechanically Separated (Species) of any other species.

(b) Mechanically Separated (Species) described in § 319.5 that has a protein content of not less than 14 percent and a fat content of not more than 30 percent may constitute up to 20 percent of the livestock and poultry product portion of any meat food product except those listed in paragraph (d) of this section.

(c) Mechanically Separated (Species) for processing described in § 319.5 may constitute up to 20 percent of the livestock and poultry product portion of any meat food product that is subject to a definition and standard of identity or composition in Part 319 which establishes a maximum limit on the fat content of such meat food product except those listed in paragraph (d) of this section.

(d) Mechanically Separated (Species) and Mechanically Separated (Species) for processing described in § 319.5 shall not be used in baby, junior, or toddler foods, ground beef, hamburger, fabricated steaks (§ 319.15(a), (b), and (d)), barbecued meats (§ 319.80), roast beef-parboiled and steam roasted (§ 319.81), corned (cured) beef cuts (§§ 319.100-319.103), certain cured pork products (§§ 319.104(a)-(e) and 319.106), tripe with milk (§ 319.308), lima beans with ham and similar products (§ 319.310), beef with gravy and gravy with beef (§ 319.313), and meat pies (§ 319.500).

Subpart B - Meat Products

§ 319.15 Miscellaneous beef products.

(a) Chopped beef, ground beef. "Chopped Beef" or "Ground Beef" shall consist of chopped fresh and/or frozen beef with or without seasoning and without the addition of beef fat as such, shall not contain more than 30 percent fat, and shall not contain added water, phosphates, binders, or extenders. When beef cheek meat (trimmed beef cheeks) is used in the preparation of chopped or ground beef, the amount of such cheek meat shall be limited to 25 percent; and if in excess of natural proportions, its presence shall be declared on the label, in the ingredient statement required by § 317.2 of this subchapter, if any, and otherwise contiguous to the name of the product.

(b) Hamburger. "Hamburger" shall consist of chopped fresh and/or frozen beef with or without the addition of beef fat as such and/or seasoning, shall not contain more than 30 percent fat, and shall not contain added water, phosphates, binders, or extenders. Beef cheek meat (trimmed beef cheeks) may be used in the preparation of hamburger only in accordance with the conditions prescribed in paragraph (a) of this section.

* (c) Beef patties. "Beef Patties" shall consist of chopped fresh and/or frozen beef with or without the addition of beef fat as such and/or seasonings. Binders or extenders, Mechanically Separated (Species) used in accordance with § 319.6, and/or partially defatted beef fatty tissue may be used without added water or with added water only in amounts such that the product's characteristics are essentially that of a meat patty. *

(d) Fabricated steak. Fabricated beef steaks, veal steaks, beef and veal steaks, or veal and beef steaks, and similar products, such as those labeled "Beef Steak, Chopped, Shaped, Frozen," "Minute Steak, Formed, Wafer Sliced, Frozen," "Veal Steaks, Beef Added, Chopped-Molded-Cubed-Frozen, Hydrolyzed Plant Protein, and Flavoring" shall be prepared by comminuting and forming the product from fresh and/or frozen meat, with or without added fat, of the species indicated on the label. Such products shall not contain more than 30 percent fat and shall not contain added water, binders or extenders. Beef cheek meat (trimmed beef cheeks) may be used in the preparation of fabricated beef steaks only in accordance with the conditions prescribed in paragraph (a) of this section.

(e) Partially defatted beef fatty tissue. "Partially Defatted Beef Fatty Tissue" is a beef byproduct derived from the low temperature rendering (not exceeding 120 °F.) of fresh beef fatty tissue. Such product shall have a pinkish color and a fresh odor and appearance.

§ 319.29 Miscellaneous pork products.

(a) Partially defatted pork fatty tissue. "Partially Defatted Pork Fatty Tissue" is a pork byproduct derived from the low temperature rendering (not exceeding 120° F.) of fresh pork fatty tissue, exclusive of skin. Such product shall have a pinkish color and a fresh odor and appearance.

Subpart C-Cooked Meats

§ 319.80 Barbecued meats.

Barbecued meats, such as product labeled "Beef Barbecue" or "Barbecued Pork," shall be cooked by the direct action of dry heat resulting from the burning of hard wood or the hot coals therefrom for a sufficient period to assume the usual characteristics of a barbecued article, which include the formation of a brown crust on the surface and the rendering of surface fat. The product may be basted with a sauce during the cooking process. The weight of barbecued meat shall not exceed 70 percent of the weight of the fresh uncooked meat.

§ 319.81 Roast beef parboiled and steam roasted.

"Roast Beef Parboiled and Steam Roasted" shall be prepared so that the weight of the finished product, excluding salt and flavoring material, shall not exceed 70 percent of the fresh beef weight. Beef cheek meat and beef head meat from which the overlying glandular and connective tissues have been removed, and beef heart meat, exclusive of the heart cap may be used individually or collectively to the extent of 5 percent of the meat ingredients in the preparation of canned product labeled "Roast Beef Parboiled and Steam Roasted." When beef cheek meat, beef head meat, or beef heart meat is used in the preparation of this product, its presence shall be reflected in the statement of ingredients required by Part 317 of this subchapter.

Subpart D-Cured Meat, Unsmoked and Smoked

§ 319.100 Corned beef.

"Corned Beef" shall be prepared from beef briskets, navels, clods, middle ribs, rounds, rumps, or similar cuts using one or a combination of the curing ingredients specified in § 318.7(c)(1) and (4) of this subchapter. Canned product labeled "Corned Beef" shall be prepared so that the weight of the finished product, excluding cure, salt, and flavoring material, shall not exceed 70 percent of the fresh beef weight. Corned beef other than canned shall be cured in pieces weighing not less than 1 pound, and if cooked, its weight shall not exceed the weight of the fresh uncured beef. Beef cheek meat, beef head meat and beef heart meat may be used to the extent of 5 percent of the meat ingredient in preparation of this product when trimmed as specified in §319.81. When beef cheek meat, beef head meat, or beef heart meat is used in preparation of this product, its presence shall be reflected in the statement of ingredients required by Part 317 of this subchapter. The application of curing solution to beef cuts, other than briskets, which are intended for bulk corned beef shall not result in an increase in the weight of finished cured product of more than 10 percent over the weight of the fresh uncured meat.

§ 319.101 Corned beef brisket.

In preparing "Corned Beef Brisket," the application of curing solution to the beef brisket shall not result in an increase in the weight of the finished

(§ 319.101 continued)

cured product of more than 20 percent over the weight of the fresh uncured brisket. If the product is cooked, the weight of the finished product shall not exceed the weight of the fresh uncured brisket.

§ 319.102 Corned beef round and other corned beef cuts.

In preparing "Corned Beef Round" and other corned beef cuts, except "Corned Beef Briskets," the curing solution shall be applied to pieces of beef weighing not less than one pound and such application shall not result in an increased weight of the cured beef product of more than 10 percent over the weight of the fresh uncured beef cut. If the product is cooked, the weight of the finished product shall not exceed the weight of the fresh uncured beef cut.

§ 319.103 Cured beef tongue.

In preparing "Cured Beef Tongue," the application of curing solution to the fresh beef tongue shall not result in an increase in the weight of the cured beef tongue of more than 10 percent over the weight of the fresh uncured beef tongue.

§ 319.104 Cured pork products, unsmoked and smoked.

(a) Cured, unsmoked products. Cured, unsmoked, "Boneless Pork Shoulder," "Boneless Pork Shoulder Butts," or pieces of pork loin in casings or similar containers of consumer size, shall not contain more than 10 percent added substances as a result of the curing process.

(b) Smoked products. The weight of any smoked products such as "Ham," "Pork Shoulder," "Pork Shoulder Picnic," "Pork Shoulder Butt," or similar products, except such products prepared for canning, shall not exceed the weight of the fresh uncured article.

(c) Other cooked, cured products. The preparation of any cooked, cured products, such as "Ham," "Pork Shoulder," "Pork Shoulder Picnic," "Pork Shoulder Butt," and "Pork Loin," or similar products, either by moist or dry heat (except such products prepared for canning), shall not result in the finished cooked product weighing more than the fresh uncured article.

(d) Cured, water added products. Products resembling standardized ham and other pork products of the kinds provided for in paragraph (b) or (c) of this section, which do not conform to such provisions because they contain added water not in excess of 10 percent of the weight of the fresh, uncured products, shall bear on their labels the term "Water Added," as a part of the product name, in prominent lettering not less than three-eighths inch in height, and if not placed in a consumer-size package labeled in accordance with this part and Part 317 of this subchapter, shall be marked with the term "Water Added" the full length of the product. However, the Administrator may approve smaller lettering for labels of small packages, such as 4-ounce packages, when he finds that the size and style of the lettering in connection

with the product name are such as to insure the prominence of the required terms. The qualifying phrase "Up to 10 percent" or equivalent phrase may be used in labeling such products in connection with the term "Water Added" at the option of the operator of the establishment, provided the qualifying phrase does not detract from the prominence of the term "Water Added."

(e) Canned products. The preparation of any canned products such as "Ham," "Pork Shoulder Picnic," or similar products, shall not result in an increase in weight of more than 8 percent over the weight of the fresh uncured article.

(f) Pressed ham, spiced ham, and similar products. "Pressed Ham," "Pressed Ham with Natural Juices," "Spiced Ham," and similar products may contain finely chopped ham shank meat to the extent of 25 percent over that normally present in the boneless ham. Mechanically Separated (Species) may be used in accordance with § 319.6. The weight of the cured chopped ham prior to processing shall not exceed the weight of the fresh uncured ham, exclusive of the bone and fat removed in the boning operation, plus the weight of the curing ingredients and 3 percent moisture.

§ 319.105 Chopped ham.

(a) "Chopped Ham" is the semisolid meat food product, in the form of a compact mass with a limited amount of cooked out juices, which is prepared with ham, curing agents, seasonings, and any of the optional ingredients listed in paragraph (b) of this section, in accordance with the provisions of subparagraphs (1), (2), and (3) of this paragraph.

(1) Fresh ham, cured ham, or smoked ham, or a mixture of two or more of such meat components may be used. The weight of the cured chopped ham prior to processing shall not exceed the weight of the fresh uncured ham and fresh uncured ham shank meat if any is used, exclusive of the bones and fat removed in the boning operations, plus the weight of the curing ingredients and 3 percent moisture.

(2) The curing agents that may be used, singly or in combination, are salt, sodium nitrate, sodium nitrite, potassium nitrate, and potassium nitrite. When sodium nitrate, sodium nitrite, potassium nitrate, or potassium nitrite is used, singly or in combination, the amount thereof shall not exceed that permitted in § 318.7(c)(4) of this subchapter.

(3) The seasonings that may be used, singly or in combination, are salt, sugar (sucrose or dextrose), spice, and flavoring, including essential oils, oleoresins and other spice extractives.

(b) Chopped ham may contain one or more of the following optional ingredients:

(1) Finely chopped ham shank meat (fresh, cured, or smoked, or a combination thereof) to the extent of not more than 25 percent over that normally present in the boneless ham;

(2) Water, for the purpose of dissolving the curing agents, and not in excess of the amount permitted in paragraph (a)(1) of this section;

(3) Monosodium glutamate;

(§ 319.105 continued)

(4) Hydrolyzed plant protein;

(5) Corn syrup solids, corn syrup and glucose syrup, singly or in combination, in an amount not to exceed 2 percent (calculated on a dry basis) of all the ingredients used in preparing the chopped ham;

(6) Disodium phosphate, sodium hexametaphosphate, sodium tripolyphosphate, sodium pyrophosphate, and sodium acid pyrophosphate, singly or in combination, in an amount not to exceed that permitted in § 318.7(c)(4) of this subchapter;

(7) Ascorbic acid, sodium ascorbate, isoascorbic acid or sodium isoascorbate in an amount not to exceed that permitted in § 318.7(c)(4) of this subchapter;

(8) Dehydrated onions or onion powder;

(9) Dehydrated garlic or garlic powder.

(10) Mechanically Separated (Species) used in accordance with § 319.6.

§ 319.106 "Country Ham," "Country Style Ham," "Dry Cured Ham," "Country Pork Shoulder," "Country Style Pork Shoulder," and "Dry Cured Pork Shoulder."

(a) "Country Ham," "Country Style Ham," or "Dry Cured Ham," and "Country Pork Shoulder," "Country Style Pork Shoulder," or "Dry Cured Pork Shoulder," are the uncooked, cured, dried, smoked or unsmoked meat food products made respectively from a single piece of meat conforming to the definition of "ham," as specified in § 317.8(b)(13) of this subchapter, or from a single piece of meat from a pork shoulder. They are prepared in accordance with paragraph (c) of this section by the dry application of salt (NaCl), or by the dry application of salt (NaCl) and one or more of the optional ingredients as specified in paragraph (d) of this section. They may not be injected with curing solutions nor placed in curing solutions.

(b) The product must be treated for the destruction of possible live trichinae in accordance with such methods as may be approved by the Administrator upon request in specific instances and none of the provisions of this standard can be interpreted as discharging trichinae treatment requirements.

(c)(1) The entire exterior of the ham or pork shoulder shall be coated by the dry application of salt or by the dry application of salt combined with other ingredients as permitted in paragraph (d) of this section.

(2) Additional salt, or salt mixed with other permitted ingredients, may be reapplied to the product as necessary to insure complete penetration.

(3) When sodium or potassium nitrate, or sodium or potassium nitrite, or a combination thereof, is used, the application of salt shall be in sufficient quantity to insure that the finished product has an internal salt content of at least 4 percent.

(4) When no sodium nitrate, potassium nitrate, sodium nitrite, potassium nitrite or a combination thereof is used, the application of salt shall be in sufficient quantity to insure that the finished product has a brine concentration of not less than 10 percent or a water activity of not more than 0.92.

(5) For hams or pork shoulders labeled "country" or "country style," the combined period for curing and salt equalization shall not be less than 45 days for hams, and shall not be less than 25 days for pork shoulders; the total time for curing, salt equalization, and drying shall not be less than 70 days for hams, and shall not be less than 50 days for pork shoulders. During the drying and smoking period, the internal temperature of the product must not exceed

(§ 319.106(c)(5) continued)

95°F, provided that such temperature requirement shall not apply to product dried or smoked under natural climatic conditions.

(6) For hams or pork shoulders labeled "dry cured," the combined period for curing and salt equalization shall not be less than 45 days for hams, and shall not be less than 25 days for pork shoulders; and the total time for curing, salt equalization, and drying shall not be less than 55 days for hams and shall not be less than 40 days for pork shoulders.

(7) The weight of the finished hams and pork shoulders covered in this section shall be at least 18 percent less than the fresh uncured weight of the article.

(d) The optional ingredients for products covered in this section are:

(1) Nutritive sweeteners, spices, seasonings and flavorings.

(2) Sodium or potassium nitrate and sodium or potassium nitrite if used as prescribed in this section and in accordance with § 318.7(c)(4) of this subchapter.

Subpart E-Sausage Generally: Fresh Sausage

§ 319.140 Sausage.

Except as otherwise provided in this section, or under the Poultry Products Inspection Act with respect to products consisting partly of poultry,

§ 381.122 Identification of manufacturer, packer or distributor.

The name and address, including zip code, of the manufacturer, packer, or distributor shall be shown on the label and if only the name and address of the distributor is shown, it shall be qualified by such term as "packed for," "distributed by," or "distributors." The name and place of business of the manufacturer, packer, or distributor may be shown on the principal display panel, on the 20-percent panel of the principal display panel reserved for required information, or on the front riser panel of frozen food cartons.

§ 381.123 Official inspection mark; official establishment number.

The immediate container of every inspected and passed poultry product shall bear:

(a) The official inspection legend; and

(b) The official establishment number of the official establishment in which the poultry product was processed under inspection, and placed as follows:

(1) Within the official inspection legend in the form required by Subpart M of this Part; or

(2) Outside the official inspection legend elsewhere on the exterior of the container or its labeling, e.g., the lid of a can, if shown in a prominent and legible manner in a size sufficient to insure easy visibility and recognition and accompanied by the prefix "P", or

(3) Off the exterior of the container, e.g., on a metal clip used to close casings or bags, or on the back of a paper label of a canned product, or on other packaging or labeling in the container, e.g., on aluminum pans and trays placed within containers, when a statement of its location is printed contiguous to the official inspection legend, such as "Plant No. on Package Closure" or "Plant No. on Pan", if shown in a prominent and legible manner in a size sufficient to ensure easy visibility and recognition; or

(4) On an insert label placed under a transparent covering if clearly visible and legible and accompanied by the prefix "P".

§ 381.124 Dietary food claims.

If a product purports to be or is represented for any special dietary use by man, its label shall bear a statement concerning its vitamin, mineral, and other dietary properties upon which the claim for such use is based in whole or in part and shall be in conformity with regulations (21 CFR Part 125) established pursuant to sections 403 and 701 of the Federal Food, Drug, and Cosmetic Act (21 U.S.C. 343, 371).

§ 381.125 Special handling label requirements.

Packaged products which require special handling to maintain their wholesome condition shall have prominently displayed on the principal display panel of the label the statement: "Keep Refrigerated," "Keep Frozen," "Keep Refrigerated or Frozen," "Perishable-Keep Under Refrigeration," or such similar statement as the Administrator may approve in specific cases. The immediate containers for products that are frozen during distribution and intended to be thawed prior to or during display for sale shall bear the statement "Shipped/Stored and Handled Frozen for Your Protection, Keep Refrigerated or Freeze." For all canned perishable products, the statement shall be shown in upper case letters one-fourth inch in height for containers having a net weight of 3 pounds or less, and for containers having a net weight over 3 pounds, the statement shall be shown in letters one-half inch in height.

§ 381.126 Date of processing; contents of cans.

(a) Either the immediate container or the shipping container of all poultry food products shall be plainly and permanently marked by code or otherwise with the date of packing. If calendar dating is used, it must be accompanied by an explanatory statement, as provided in § 381.129(c)(2).

(b) The immediate container for dressed poultry shall be marked with a lot number which shall be the number of the day of the year on which the poultry was slaughtered or a coded number.

(c) All canned product shall be plainly and permanently marked, by code or otherwise, on the containers, with the identity of the contents and date of canning, except that canned products packed in glass containers are not required to be marked with the date of canning if such information appears on the shipping container. If calendar dating is used, it must be accompanied by an explanatory statement, as provided in § 381.129(c)(2).

(d) If any marking is by code, the inspector in charge shall be informed as to its meaning.

§ 381.127 Wording on labels of shipping containers.

(a) Each label for use on a shipping container for inspected and passed poultry products shall bear, in distinctly legible form, the following information:

(1) The official inspection legend.

(2) The official establishment number of the official establishment in which the poultry product was inspected, either within the official inspection mark, or elsewhere on the container clearly visible and in proximity to the official inspection mark.

§ 381.128 Labels in foreign languages.

Any label to be affixed to a container of any dressed poultry or other poultry product for foreign commerce may be printed in a foreign language. However, the official inspection legend and establishment number shall appear on the label in English, but in addition, may be literally translated into such foreign language. Each such label shall be subject to the applicable provisions of §§ 381.115 to 381.141, inclusive. Deviations from the form of labeling

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